



Dart Aerospace Ltd.
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D3198-1
Job Sheet 179691



Part No: D3198-1

Job Qty: 12 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP: A 03.11.11 New Issue KJ/RF IPP Rev:B Now on Waterjet 07-01-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/18
100	Waterjet	12 pcs	7/18/18	7/18/18	0.00	0.78	Waterjet1		SC 18/07/18
120	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
130	Brake NC	12 pcs	7/18/18	7/18/18	0.03	0.75	Brake NC 1		9-89
140	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC5		15-07-31
150	Powdercoat	12 pcs	7/18/18	7/18/18	0.00	0.22	Powdercoat3		18-18-07
160	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC3		38
170	Packaging	12 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1	5x021	AUG 18 2018
180	QC21-SA	12 Ea	7/18/18	7/18/18	0.00	0.00	QC21		DAS

Part Op 100 - 1-Cut as per Dwg D3198

Descriptions: 130 - 1-Deburr if necessary 2-Form as per Dwg D3198

150 - START TIME: 7:30AM 8:00PM 320°C

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.2600 sf (.105 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	1	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.266inches + 0.006 - 0.001	0.272 0.265	0.268	
2	Fitting	4.280inches ± 0.010	4.290 4.270	4.285	
3	Fitting	2.500inches ± 0.010	2.510 2.490	2.502	
4	Fitting	3.420inches ± 0.010	3.430 3.410	3.426	
5	Fitting	0.400inches ± 0.010	0.410 0.390	0.401	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Suspec ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Performing ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		Completed By _____ Hand / Supervisor _____ Approval Verification _____ QA Coordinator Approval _____			
Description Work Order Deviation							

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

☐ Press	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter
☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Weld	☐ Wrong Stock Pulled
☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing
☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence					

6	Fitting	0.400inches ± 0.010	0.410 0.390	0,402
7	Fitting	3.880inches ± 0.010	3.890 3.870	3,887
8	Fitting	2.100inches ± 0.010	2.110 2.090	2,105
9	Fitting	3.020inches ± 0.010	3.030 3.010	3,024

Plex 6/21/18 7:08 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					